

Date: Wednesday, 22/04/2009 1:52:34 PM
 User: Mélanie Fauteux

Process Sheet

See 1
 Page

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 47379
 Estimate Number : 13851
 P.O. Number :
 This Issue : 22/04/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL / MED FAB
 Previous Run : 47232

Drawing Name : BRACKET
 Part Number : D35703
 Drawing Number : D3570 REV D PRELIM
 Project Number : N/A
 Drawing Revision : D PRELIM
 Material :
 Due Date : 23/04/2009

Qty: 500423
 4 Um: 1 Eac.

Written By :
 Checked & Approved By : MF 09-04-22
 Comment : Est Rev:A New Issue 09.04.14 EC verified by:DD

Additional Product

Job Number:



PRELIMINARY ISSUE
 09.04.23

Seq. #: Machine Or Operation:

Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.0746 sf(s)/Unit Total : 0.2982 sf(s)
 6061-T6 .125 Sheet

Batch: 110067 IB 9-4-22
 IB 9-4-24
 Grain must be Along 4.63**

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3570

Dwg Rev: PRE

Prog Rev: Lim

2-Deburr if necessary

IB 9-4-24

IB 9-4-22

IB 9-4-24

IB 9-4-22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8



SECOND CHECK

**ENGINEERING
 APPROVAL**

Comment: SECOND CHECK

5.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D3570 Using DT8945

FF 09-04-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7/1/23	#5	Pound A11 5 parts to be bent too long. Dwg Ask Per 3.90 measure dont 4.100 b 4.160"	04/04/23 JAL QA CAR	SCRAP AND DESTROY 1100062 Repr B# 1100062 and re form and drill	FB 09-04-24 BQA	S 07/04/24	04/04/23 JAL QA CAR	S 07/04/23
		RC Heman error		As Per Dwg				S 07/04/23

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47379

Part Number: D35703

Job Number:



see last
page
(10)

Seq. #:

Machine Or Operation:

Description :

2-Cut excess material per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

FF 09-04-24 (5)
FF 09-04-23

(2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

09.04.24 / S 02/04/24

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

CMD/bk

09/04/24

(x2)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109091

START TIME:

10:50

OVEN TEMPERATURE:

320°

FINISH TIME:

11:50

BR 09-04-24

(2)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 02/04/24 (x2)

(-3)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

GA. MF 09-04-24

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/24

(2)

Job Completion



POSITIVE RECALL

EFFECTIVE

RELEASED

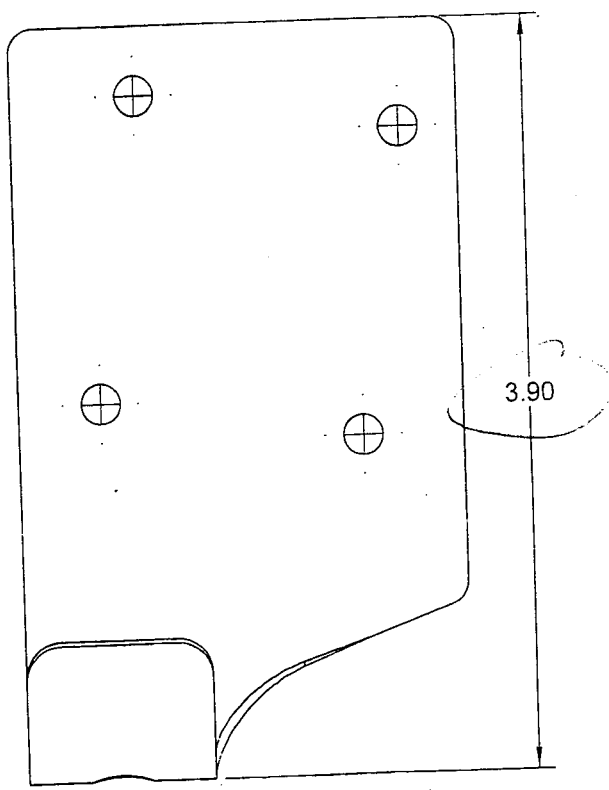
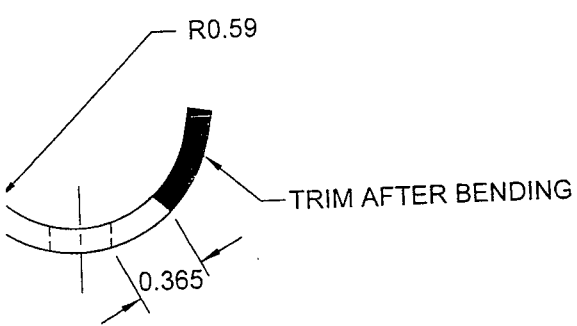
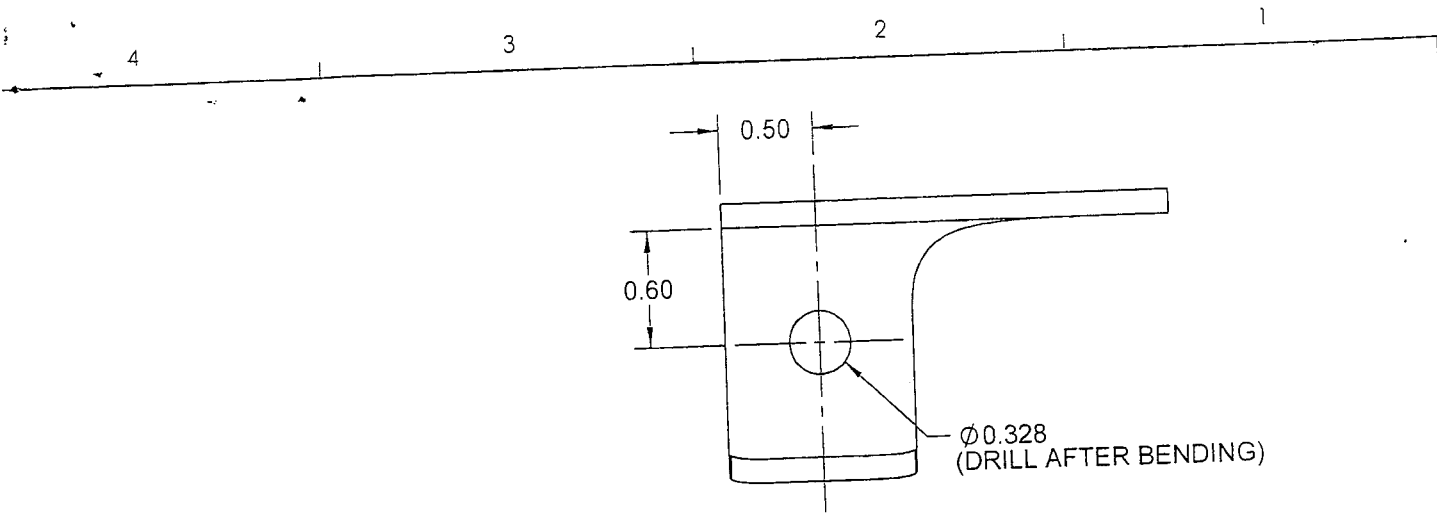
AUTH

DATE

09.04.24

MF 09-04-24




Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3570-3 BRACKET
(MAKE FROM D3570-3F)

47379

PRELIMINARY
ISSUE
AJS 04.04.22

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3570	REV. E SHEET 4 OF 5
MFG. APPR.		TITLE BRACKET	SCALE NTS
APPROVED			
DE APPR.			
DATE	09.04.22	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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8

7

6

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11045

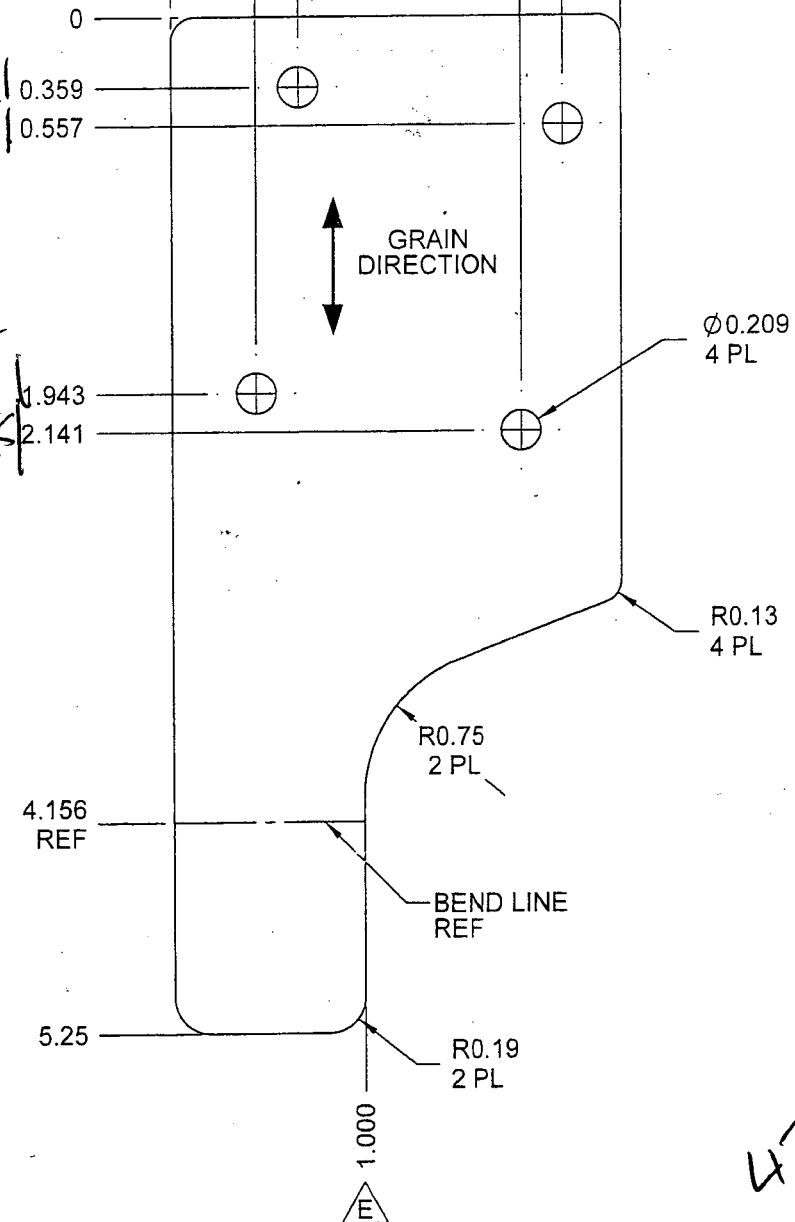
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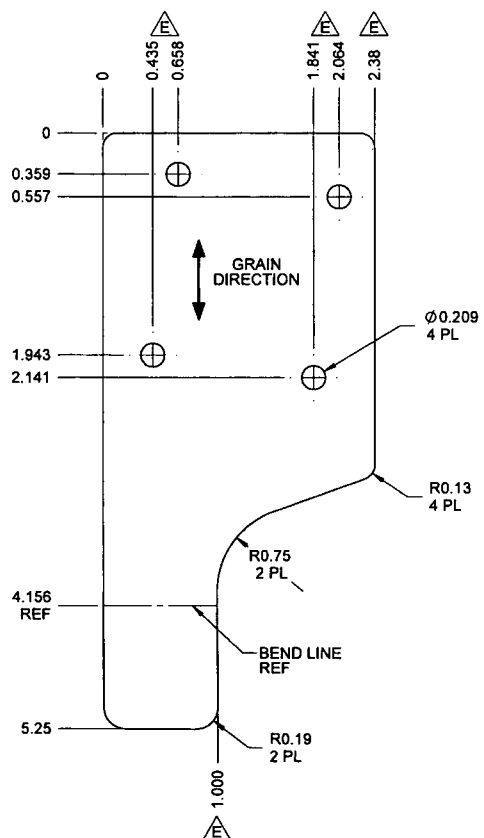
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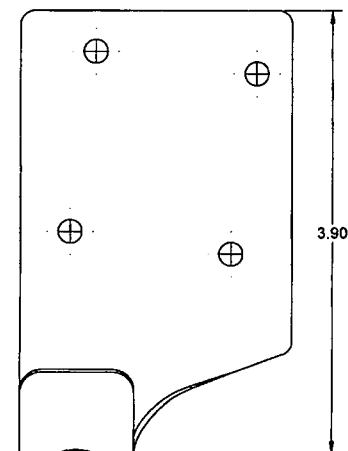
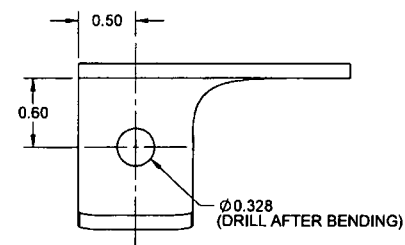
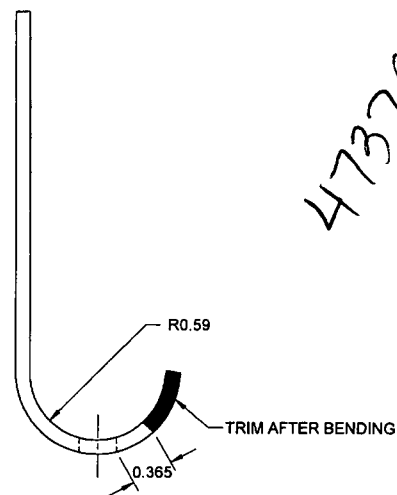


D3570-3F FLAT PATTERN

47379



D3570-3F FLAT PATTERN



D3570-3 BRACKET
(MAKE FROM D3570-3F)

RELEASED
07/04/13 MB

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	E	D3570	SHEET 4 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	140	BRACKET	NTS
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